

Date: Thursday, 07/08/2008 4:20:53 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	41054		
Estimate Number :	11036		
P.O. Number :		Part Number :	D2804041
This Issue :	07/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2804 REV C
First Issue :	//	Project Number :	N/A
Previous Run :	40278	Drawing Revision :	C
	Type :	Material :	
	SMALL /MED FAB	Due Date :	25/08/2008
Written By :		Qty:	6 Um: Each
Checked & Approved By :	<u>JLD 08-8-08</u>		
Comment :	Est F 05.03.30 MS21043-3 was MS21042L3 KJJ/JLM Est Rev:G As per Rev C 06-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D28041	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number Description Batch

1	D2804-1	Bracket	41080
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2.0	D28051	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Stop

Pick:

Qty Part Number Description Batch

1	D2805-1	Stop	B35852 2x B41081 4x
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3.0	D2809	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

1	D2809	Bushing	33631
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4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-1 Into arm as per Dwg D2804

C 08/09/18 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/08/2008 4:20:53 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41054

Part Number: D2804041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/09/19 (86)

6.0

POWDER COATING

POWDER COATING



M 108523



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:15
320°F
1:45

M-P 08/09/19

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8 08/09/22 (6)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

8 08/09/22 (6)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M 105426

8 08/09/22

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

2

MS21043-3

Nut

M 109147

8 08/09/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41054

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Pick:

Qty Part Number Description

Batch

4 NAS1515H3

Washer

M107101

A/R LPS-3

Corrosion Spray

11/09929

08/09/22

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

08/09/22 (6)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/22 (6)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST149

08/09/22 (x6)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/22

Job Completion



MF 08-09-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

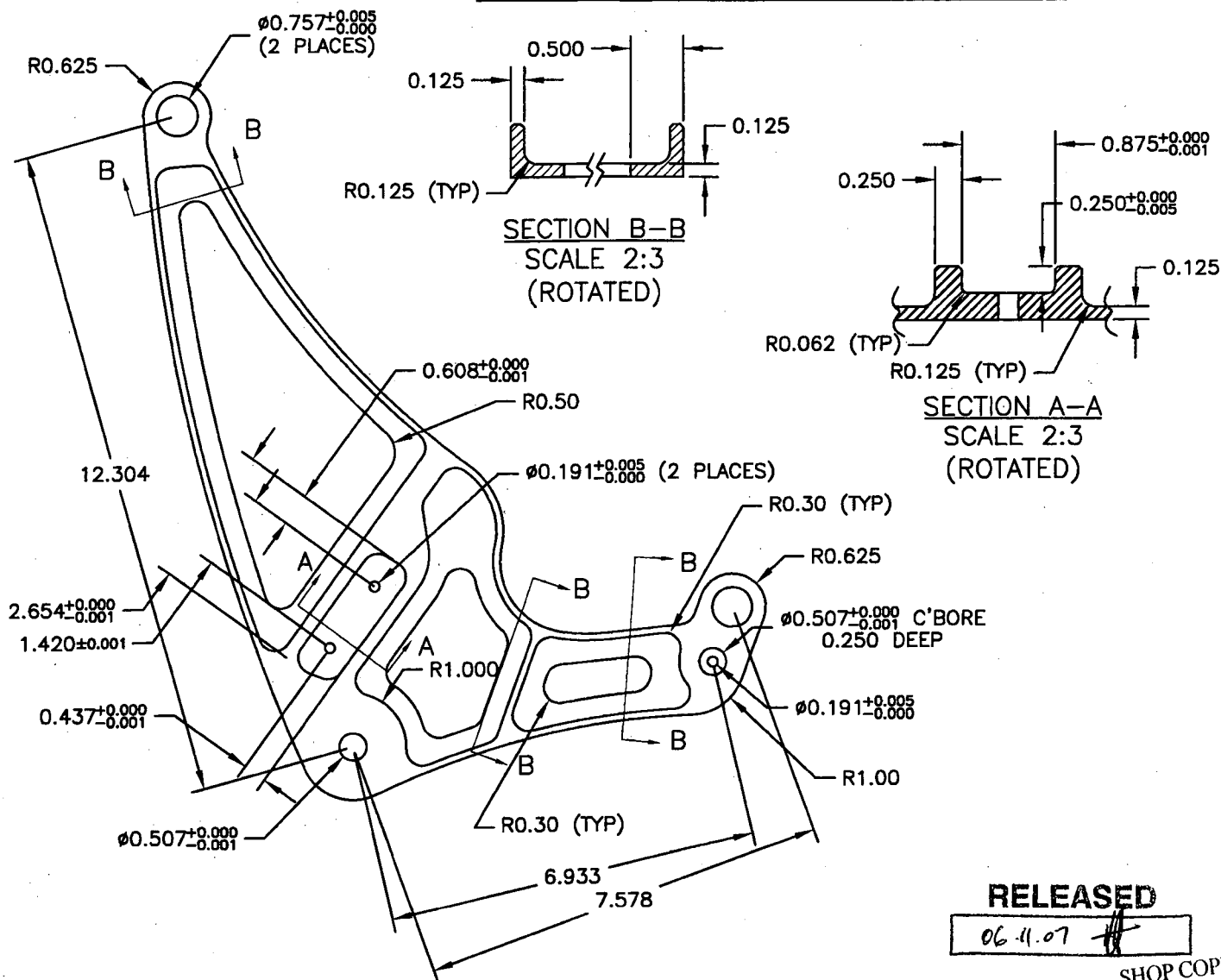
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE			

**RELEASED**06.11.07 *[Signature]***D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

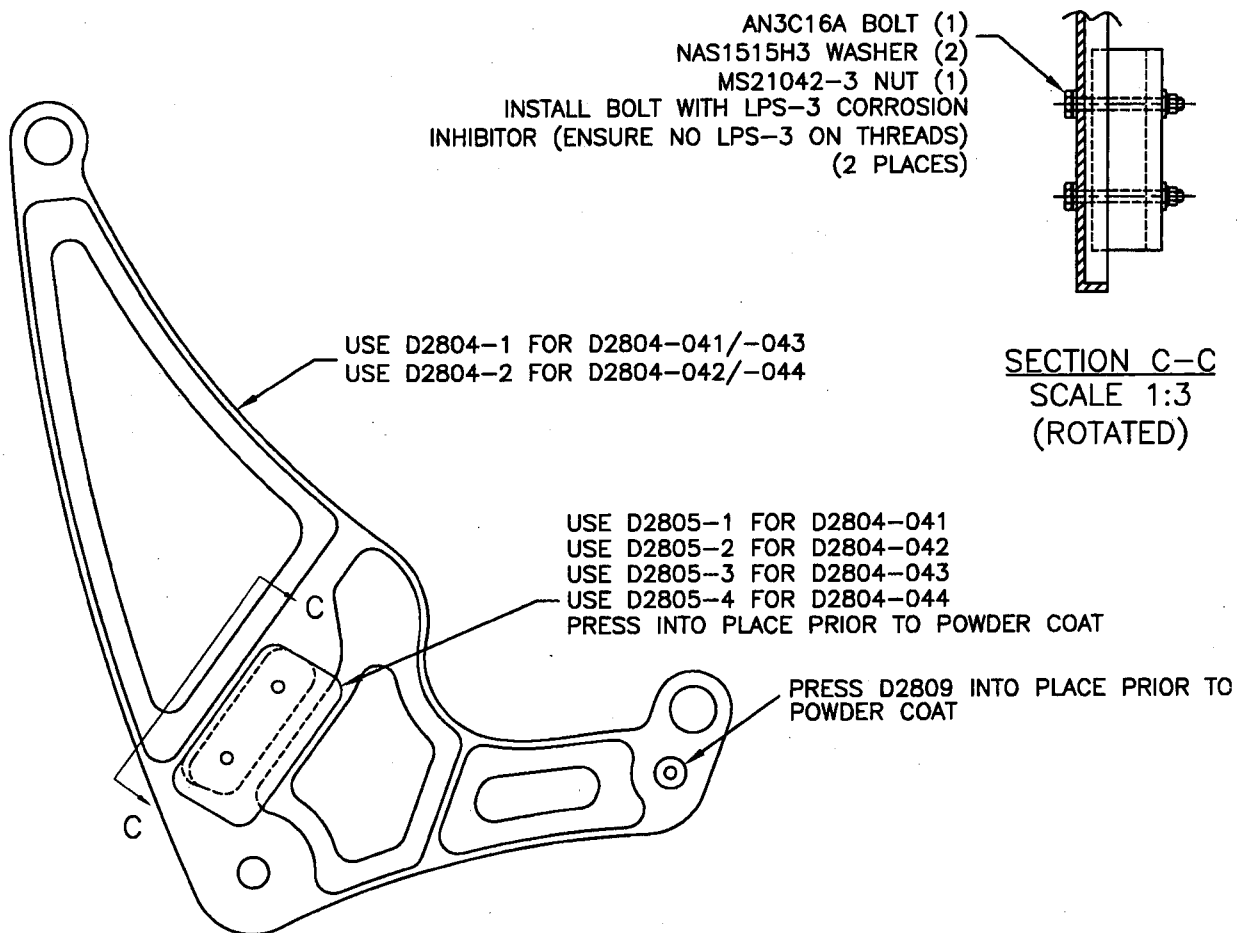
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NO. 44054

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



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NO. 41054

RELEASED06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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